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D135-751-011
Job Sheet 183649



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 10/26/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD VERF:JLM

Ship Via:



1270 ABERDEEN STREET
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S113729



Part: D135-751-011

Job No: 183649

Serial No/Batch: S113729

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01709SE 15/10/28, TC LoA RDIMS

Powder Coat
START: 8:35

TEMP: 320°
FINISH: 9:05

M13895-1
TIME worked: 0.17

BLK-10-22

J18

Job Routing

P No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/26/18	0.00	0.00	Start Up Skidtubes-1		DD
120	Skidtubes	1 pcs		10/26/18	0.00	0.80	Skidtubes-1		DD DAS 38
140	QC	1 pcs		10/26/18	0.00	0.00	QC5		
150	HandFinish	1 pcs		10/26/18	0.00	0.33	HandFinish1		DR 18/09/18
160	QC	1 pcs		10/26/18	0.00	0.00	QC7-1		BE
170	Skidtubes	1 pcs		10/26/18	0.00	1.00	Skidtubes-1		BE DAS 38
180	QC	1 pcs		10/26/18	0.00	0.00	QC10		
185	HandFinish	1 pcs		10/26/18	0.00	0.10	HandFinish6		BE 18-01-13
187	QC	1 pcs		10/26/18	0.00	0.00	QC7-1		BE
190	Skidtubes	1 pcs		10/26/18	0.00	0.77	Skidtubes-1		BE DAS 38
200	QC	1 pcs		10/26/18	0.00	0.00	QC5		
210	HandFinish	1 pcs		10/26/18	0.00	0.08	HandFinish2		DR 18/09/18
215	Outsource	1 pcs		10/26/18			ATE003-VC	5	ulu
220	SprayPaint	1 pcs		10/26/18	0.00	0.25	Spray Paint		ulu
230	QC	1 pcs		10/26/18	0.00	0.00	QC14		HL 18-10-2
260	HandFinish	1 pcs		10/26/18	0.00	0.74	HandFinish4		HL 18-10-2
270	QC	1 pcs		10/26/18	0.00	0.00	QC5		OCT 23 2018
280	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging1-1	DAS 69	OCT 24 2018
290	QC	1 pcs		10/26/18	0.00	0.00	QC4	DAS 69	OCT 24 2018
300	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging3-1	9-89 69	OCT 24 2018
305	DC	1 pcs		10/26/18	0.00	0.00	DC	9-89	OCT 24 2018
310	QC21-FG	1 Ea		10/26/18	0.00	0.00	QC21		OCT 24 2018

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & DT8870 & Dr
 Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt hole
 using #30" drill. ****DO NOT OPEN AFT CAP HOLES**** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot
 for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using
 DT8892. Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap hole
 using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out
 manually, open to #30. 13-Deburr holes.

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-
 Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg
 D3507 & QSI 015 start time : _____ end time: _____ 5-Weld x-bolt spacers as per Dwg D3507
 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: _____ 2- Paint two cos of
 White paint as per QSI 005 4.2 and dwg A/R Paint Batch: _____

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps
 as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note: Install (1) Bolt and (1) washer in
 Ground Wire insert on top of tube Do not Install Screws where indicated on Dwg (Note #6) 4-assemble o-ring to plugs per
 dwg D3492 and apply o-ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: M138943

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

Job BOM					006019
Part / Item	Component Name	Quantity	Operation	Container	
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation	5089120	
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5077412	
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes	3105604	
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5092232	
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes	5080958	
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes	5091974	
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes	5091971	
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes	5066193-1	
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish	5058138	
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish	5084123	
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish	5095277	
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	5095210	
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	5071661-2	
D2965	Cap	1 Ea (1 ea)	260-HandFinish	5045482	
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	F126365	
D3492-1	Plug	4 Ea (4 ea)	260-HandFinish	5090810	
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish	5107030	
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish	F106110	
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish	5089861	
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish	5082207	
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish	5081642	
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish	5081643	
NAS1149C0332R	Washer 5071663 (x20)	33 Ea (33 ea)	260-HandFinish (x13)	5089462	
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish	F103697	
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish	5106792	
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish	5057659	
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging	5090636	
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging	5083701	
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging	5104354	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3507-1-BENT	1	2	0
170-Skidtubes	D3504-1	2	12	0
	D3504-3	1	18	0
	D3504-5	2	38	0
	D3505-1	1	6	0
190-Skidtubes	D3506-1	4	48	0
	D3506-3	2	28	0
	MS20601-AD4W3	12	889	0
260-HandFinish	ALS4-1032-225	1	1,947	0
	ALS7-1032-130	38	1,267	0
	AN3C4A	31	2,249	0
	AN3C5A	2	1,934	0
	AN526C1032R10	2	110	0
	D2965	1	50	0
	D2965-3	1	10	0
	D3492-1	4	108	0
	D3492-3	4	153	0
	D3492-7	2	19	0
	D4918-047	1	7	0
	D4918-1	1	9	0
	D4918-3	1	8	0
	D4918-5	1	3	0
	NAS1149C0332R	33	5,199	0
	NAS1611-007	2	270	0
	NAS1611-010	4	433	0
	NAS1611-013	4	290	0
280-Packaging	AN3C4A	8	2,249	0
	D3512-041	2	5	0
	NAS1149C0332R	8	5,199	0

Part Specifications

Specifications could not be found.

Plex 9/21/18 4:01 PM dart.white.jesse

PARTS LIST:

THE PARTS LISTS IN SECTION 32.9 OF ICA-D135-751 (PAGE 35) AND SECTION 5.0 OF IIN-D135-751 (PAGE 11) ARE AMENDED AS FOLLOWS FOR D135-751-011 @ CHG 002 AND LATER.

REFERENCE ONLY**32.9 PARTS LIST (ICA-D135-751)****5.0 PARTS LIST (IIN-D135-751)**

Item	QTY -011	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X			D135-751-011	SKIDTUBE INSTALLATION
	(1)	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT

IS:

20A	1		1	D4918-1	WEARPLATE (REPLACES D3508-1)
21A	1		1	D4918-3	WEARPLATE (REPLACES D3508-3)
22A	1		1	D4918-5	WEARPLATE (REPLACES D3508-5)
23A	1		1	D4918-047	WEARPLATE (REPLACES D3508-7)
27	(2)		2	D3512-041	WEARPLATE (REPLACES D3512-1)

WAS:

20A	1		1	D3508-1	WEARPLATE
20B	1		1	D3558-1	GASKET
21A	1		1	D3508-3	WEARPLATE
21B	1		1	D3558-3	GASKET
22A	1		1	D3508-5	WEARPLATE
22B	1		1	D3558-5	GASKET
23A	1		1	D3508-7	WEARPLATE
23B	1		1	D3558-7	GASKET
27	2		2	D3512-1	WEARPLATE

THE PARTS LIST FOR THE DSI 9661-011 KIT IS AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9661-011	WEARPLATE UPGRADE KIT
1	D4918-047	WEARPLATE
2	D3512-041	WEARPLATE

REFERENCE ONLY

DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	UP	DRAWING NO. DSI 9661	REV. A
MFG. APPR.	N/A		SHEET 2 OF 3
APPROVED	JP	TITLE REVISED WEARPLATE KIT	SCALE
DE APPR.			NTS
DATE	13.08.21	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	2		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: C

Date: 07.09.20

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Description: SKIDTUBE

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